

Abstract

The present invention relates to a method for manufacturing a throttle valve unit having a housing part (10, 13, 53) and a valve flap part (17, 18, 23) that can move in relation to it. The method comprises the following steps:

First, the injection molding of the housing part (10, 13, 53) of a first plastic material in a first cavity. The premolded part (41) of the housing part (10, 13, 53) thus obtained is transferred to a second cavity spatially decoupled from the first cavity. In the second cavity (42), the movable valve flap part (17, 18, 23) is injection molded out of a second plastic material (57) inside the premolded part (41) of the housing part (10, 13, 53). Before the premolded part (41) is transferred to the second cavity (42), it is subjected to an intermediate treatment in order to influence the shrinkage behavior, thereby selectively adjusting the gap geometries between the parts (41; 17, 18, 23).

(Fig. 6)